

SLIP 20/03

Date: Tuesday, 18/03/2008 7:16:07 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID			
Job Number	: 38070						
Estimate Number	: 10193						
P.O. Number	:			Part Number	: D2512		
This Issue	: 18/03/2008	S.O. No. :			Drawing Number : D2512 UNDER REVIEW		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type : LARGE FAB ASSY	Drawing Revision	: D2		
Previous Run	: 37723A			Material	:		
Written By	:			Due Date	: 20/03/2008		
Checked & Approved By	:			Qty:	1 Um: Each		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF			Est Rev:N 06.04.05 Added level21	EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick:	
		3/4"x3/4" 304/316 SS tube .063" wall	
		Batch: M107315 ✓	SL 08/03/18
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D3166-3	Basket Hoop	B37612 ✓
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	1 D2506	Label Plate	B35585 ✓
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2327-1	Bushing	B336920 ✓
			PL 08/03/19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 09/03/200 _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/03/2008 7:16:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 38070

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

D 08/03/20

11.0 POWDER COATING POWDER COATING



M 107005



(P)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 08/03/20

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray Paint: m 107230
Batch: m 107385

Fd 08/03/20

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



1080320 (0)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

108/3/20 (1)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

108/03/20

Job Completion



108/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



3rd COPY
ISSUED

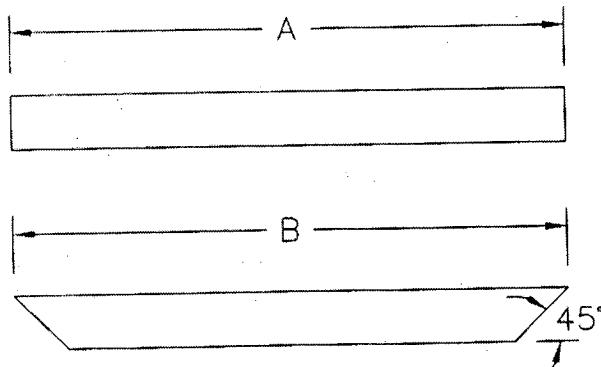
DESIGN BW	DRAWN BY <i>SP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>SP</i>	APPROVED <i>SP</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

RELEASED
01.04.27 AD

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	03.01.20	ADD D2512-117 FOR D130-701-041
D2	04.01.20	FRONT WEIG PLATE 5MM OPEN

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



UNDER REVIEW
08-04-05 AM

TUBING TO BE
CHANGED TO 0.065
WALL

W/0
38070

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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RELEASED
01.04.19

MESH

D2506 LABEL PLATE (REF)

UNDER REVIEW
08-02-05 AM
TUBING TO BE
CHANGED TO 0.055
WALL

SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.



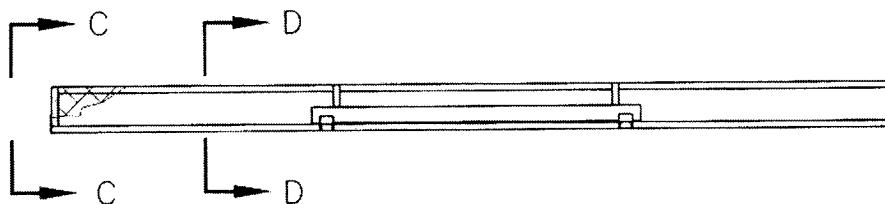
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY

D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

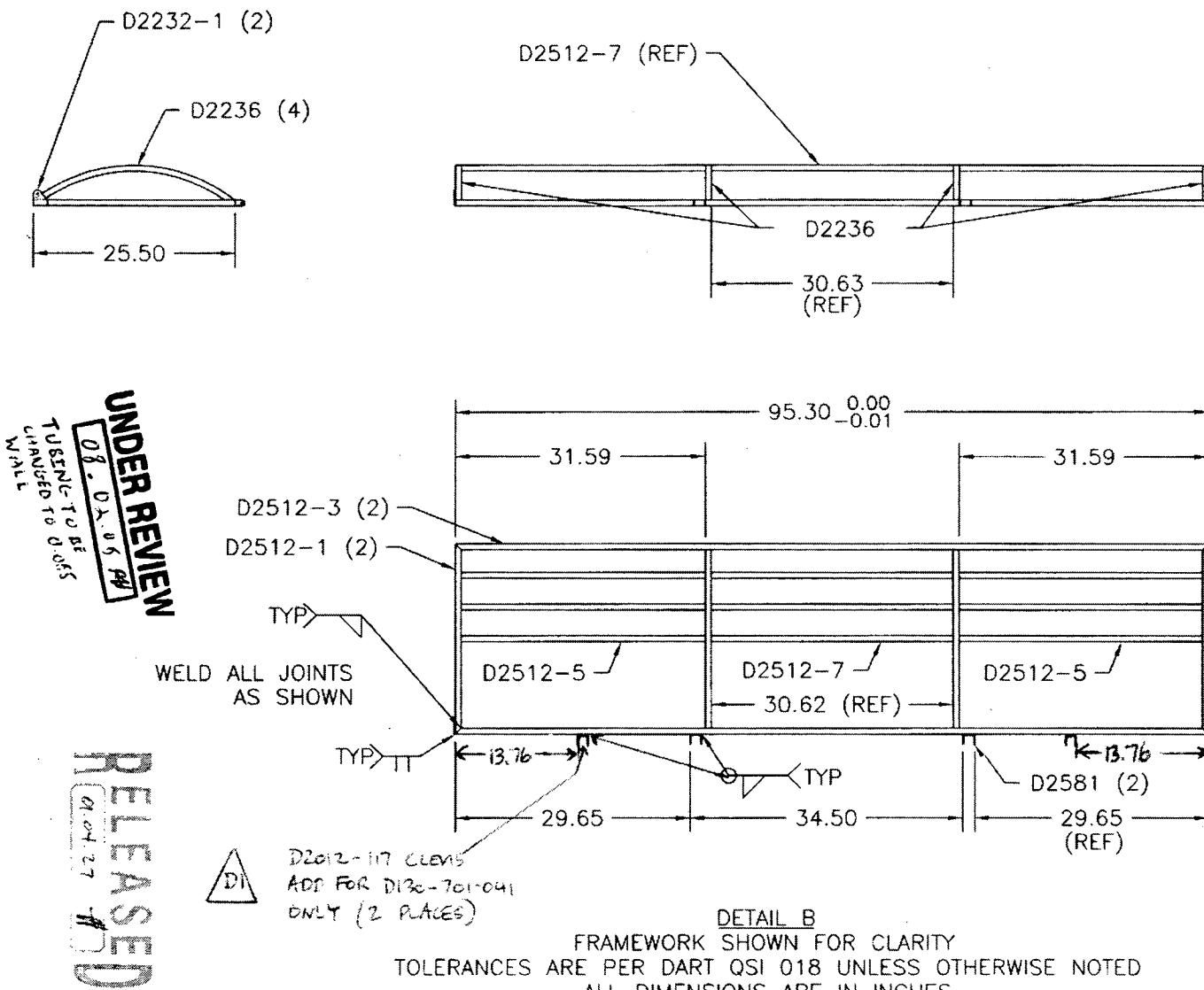
DART

OK COPY
05/04/01

DESIGN BW	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED A	APPROVED A	DRAWING NO. D2512
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV D SHEET 2 OF 4 SCALE 1:20

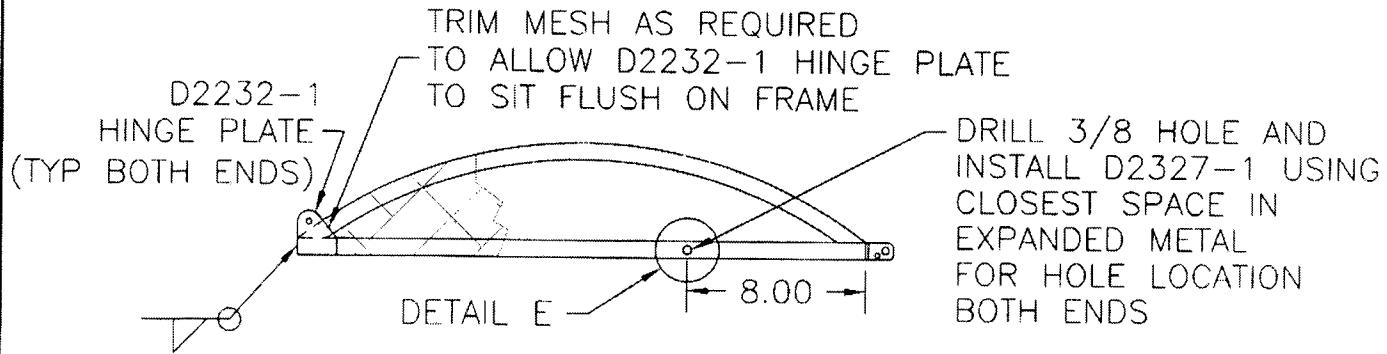
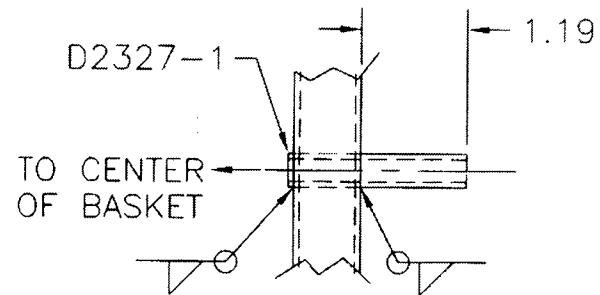
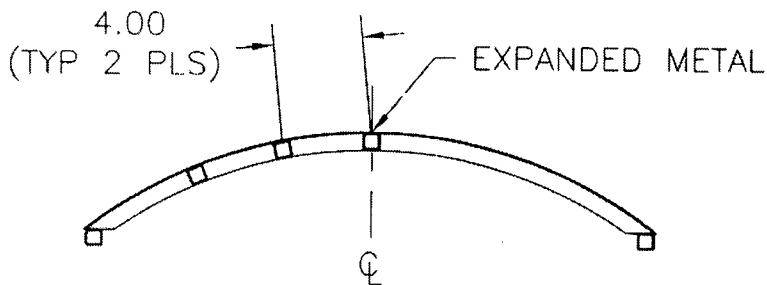
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DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>JP</i>	<i>JP</i>	D2512
DATE		TITLE
01.04.19		BASKET LID ASSEMBLY (350/212)
		REV. D
		SHEET 3 OF 4
		SCALE
		1:20



DARTGACOPY
C3515

DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILIAR BOTH END RIBSDETAIL ESECTION D-D SAME BOTH CENTER RIBS

UNDER REVIEW
08.02.05 AM
TUBING TO BE
CHANGED TO 0.055
WALL

RELEASED
01.04.19 *[initials]*